

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave.St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-016018**Date Inspected:** 29-Jul-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Geng wei / Xu Tao**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Components**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, S.Chandrakumar was present during the times noted above for observations relative to the work being performed.

BAY#14

SMAW welding of repair weld joint 4G-242 located on PCMK SEG3006M for Segment 12CW the welder is identified as 045246. ZPMC QC is identified as Mr. Guo xing hui. The welding variables recorded by QC appeared to Comply with the WPS-345-SMAW-4G(4F)-FCM-Repair.

SMAW welding of critical repair weld joint 2F-038 located on PCMK SEG3006S for Segment 12CW the welder is identified as 040344. ZPMC QC is identified as Mr. Guo xing hui. The welding variables recorded by QC appeared to Comply with the WPS-345-SMAW-2G(2F)-Repair and CWR-1754.

SMAW welding of critical repair weld joint 2F-056 located on PCMK SEG3005S for Segment 12CW the welder is identified as 040344. ZPMC QC is identified as Mr. Guo xing hui. The welding variables recorded by QC appeared to Comply with the WPS-345-SMAW-2G(2F)-Repair and CWR-1754.

FCAW welding of weld joint 3G-016 located on PCMK DP305-001 for Segment 12BW the welder is identified as 045175. ZPMC QC is identified as Mr. Guo xing hui. The welding variables recorded by QC appeared to Comply with the WPS-345-FCAW-3G(3F)-Repair.

This QA inspector performed 15% MT of weld areas previously tested and accepted by ZPMC Quality Control

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personnel. This QA inspector generated an MT report for this date. The members are identified as OBG Side panel for Lift 13. The weld designations reviewed as follows.

SP3074-001-007,009,011,015,018,023,078,046. Green Tag-13587.

BAY#16

ZPMC personnel removing (18nos)stiffener which is previously completed fit-up with longitudinal diaphragm (LD) is identified as LD3036-001 for Segment 13CW. This LD web plate is identified as X4142A (SPCM) and the stiffener is identified as X4325T.No repair report made during removal of the stiffeners. As per ZPMC QC Mr.Xu tao repair report to be made prior to welding.

BLAST SHOP#1

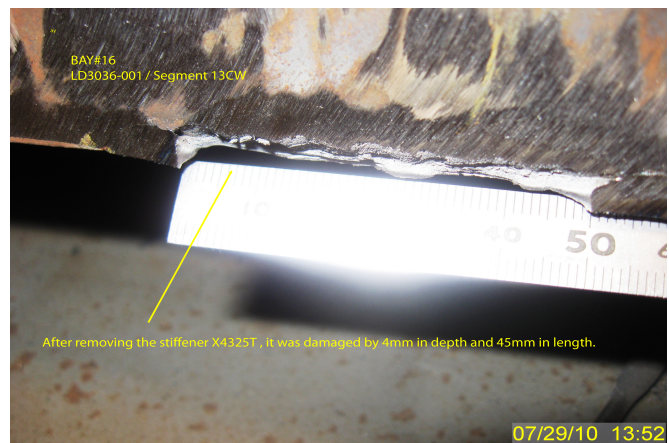
During random in-process Visual inspection of OBG Segment 10BE after Abrasive Blasting this Caltrans Quality Assurance Inspector (QA) discovered the following issue:

- Distortion of approximately 5mm in depth and for a length of 80mm in continuous observed at Deck panel U-Rib.
- This deck panel is identified as DP425 (PL445B) and the U-rib is identified as (RS23C).
- This is 18th U-rib from the CA75.

For more information please see the Incident report

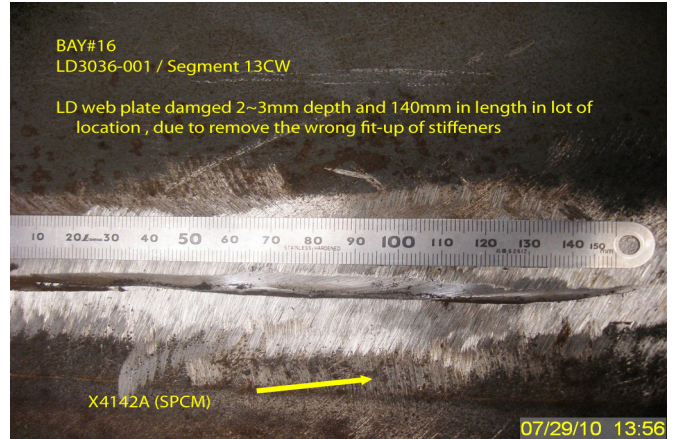
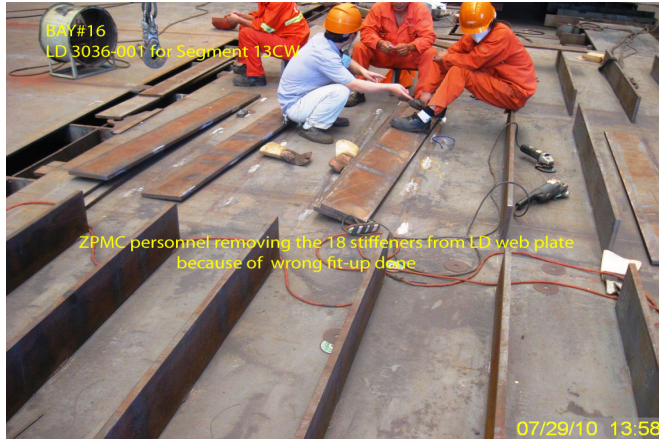
04-0120F4_TL-15_B247_07-29-10_Distortion in Deck panel U-rib DP425@Segment 10BE

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



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Summary of Conversations:

No relevant Conversation.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang-15--0042-2372, who represents the Office of Structural Materials for your project.

Inspected By:	Kumar,Chadra	Quality Assurance Inspector
Reviewed By:	McClendon,Timothy	QA Reviewer
